

Work Order ID 84893

84893

Page 1

Item ID: D209-669-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/29

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2906

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 003 per 9/12/591

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

-Open holes to 0.500" as per Dwg D2906 without cutting fluid

-Deburr and blow out all chips from

-Acid etch and Alodine tube per QSI 005 4.1

CF 12-6-11
SAD 12-06-11
KC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop ***NS2***

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Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC3- Inspect Part Finish 0.00

120

QC Memo 0.00

Quality Control

130 0.00

130

Skidtubes Memo 0.00

Skidtubes -Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M121409

Sikaflex expire date: 13-4-12

Start Time: 16:00 Date: 12-6-11

Fin Time: 2:00 Date: 12-07-04

pick:

Qty	P/N	description	B/N
1	D2926-3	Web	

① SMO A-06-11

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140	BENDING MACHINE - CROSSTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906								
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	-Deburr ends and remove marks from bending								
	- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

> DP 12-6-13

SAD 12-06-13

- PC 12/07/04

BB 12/07/04

1 0 12/07/04

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Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	Large Fab								
Skidtubes		0.00							
Skidtubes	<div>Memo</div> <div>-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web.Deburr</div> <div>-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr</div> <div>-Drill pilot holes for Tow ring using DT8091-3 , open to .640"and Deburr</div>								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC		0.00							
Quality Control	<div>Memo</div>								

DP 12-7-4

Salinas

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Pressure Wash per QSI005 4.3	0.00				1	0	6012-7-5	
200									
HandFinish	Memo	0.00							
Hand Finishing									
210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1X	0	M-L	12/07/05
210									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:00								
	OVEN TEMPERATURE: 320 OF								
	FINISH TIME: 10:30								
220	QC3- Inspect Part Finish	0.00				1X	0	M	12/07/05
220									
QC	Memo	0.00							
Quality Control									

W121841

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

230

HandFinish

Hand Finishing

HandFinishing

0.00

0.00

Memo

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on

insert holes before installing wearplates

A/R Sikaflex-291 11/12/1409

Sikaflex expire date: 12/10/13

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 11/12/1409

Sikaflex expire date: 12/10/13

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: 11/12/1409

1x of 11/12/1409

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Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240 QC5- Inspect part completeness to step on W/O

0.00

240

QC

Quality Control

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

250

0.00

250

Packaging

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD209-669-043

Location:

PPP Rev:

PPD84912

260

0.00

260

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

P12/1/23

MLJ 12/07/23

MLJ 12/07/23

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 84893

84893

Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 *D4202-1* Spacer		Manufactured	No				Each	81.0000		19			
									**			DL 12/07/04	
				<u>Location</u>	<u>Loc Qty</u>			<u>Loc Code</u>				(19)	
				LG	5								
				77727	5								
				LG002	76								
				78806	6								
				79810	70								
D2500-1-190 *D2500-1-190* Ext'n -1' Beam Tube 4"		Manufactured	No			110	Each	91.0000	1	1			
									**			CF 12-11	
				<u>Location</u>	<u>Loc Qty</u>			<u>Loc Code</u>					
				HALL	91								
				74777	14								
				80061	77								
D2926-3 *D2926-3* Web		Manufactured	No			110	Each	0.0000	1	1			
									**			CF 12-11	
D2855 *D2855* Cap		Manufactured	No			230	Each	21.0000	2	2			
									**			12/07/09	
				<u>Location</u>	<u>Loc Qty</u>			<u>Loc Code</u>					
				FP002	21								
				65519	2								
				73347	16								
				75074	3								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

230

Each

1,090.000

4

4

*AN3-5A*7

Bolt

**

ML 11/07/05

Location

Loc Qty

Loc Code

ST350

1090

115371

46

117423

124

118626 X

31

119355

200

120187

500

121185

189

AN960JD10L

NAS1149D0332J

Purchased

No

230

Each

0.0000

4

4

*AN960JD10L *

Washer

M121011

**

(x4) ML 11/07/05

ALS7-1032-130

Purchased

No

230

Each

2,136.000

44

44

AL S7-1032-130 X

Insert

**

ML 11/07/05

Location

Loc Qty

Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

2085

119530

73

120181

12

121444

2000

ALS4-1032-130

M1212264

x44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

44

44

AN3C4A

BOLT

**

HL 12/07/05

Location

Loc Qty

Loc Code

ST350

1458

120187

57

120521

28

120769

38

121205

1000

✓44

121556

335

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

44

44

***AN960C10I *✓**

washer

D2594-3

Manufactured

No

230

Each

2,418.000

14

14

D2594-3

O-Ring, 205 Skidtube

**

HL 12/07/05

HL 12/07/05

Location

Loc Qty

Loc Code

FP001

2418

65518

41

79496

984

79573

50

79755

1343

✓14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D209-669-043

D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

D2594-1

Plug, 205 Skidtube

**

JL 12/07/05

Location

Loc Qty

Loc Code

FP001

98

73401

30

74442

18

79495

50

FP-A

213

73401

0

78590

213

XL

D3564-9

Manufactured No

230

Each

22.0000

1

1

D3564-9

Wearshoe

**

JL 12/07/05

Location

Loc Qty

Loc Code

FG

4

76950

4

FP001

18

67590

4

69943

1

82255

13

XL

D3564-11

Manufactured No

230

Each

8.0000

1

1

D3564-11

Wearshoe

**

JL 12/07/05

Location

Loc Qty

Loc Code

FG

4

77056

4

FP001

4

80341

4

B84871

XL

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Shop Packet Print

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D209-669-043

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5	Manufactured	No	230	Each	13.0000	1	1	
D3564-5								
Wearshoe								
						**		<u>12/07/05</u>

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
34806	2	
FP001	11	
77609	3	
<u>82254</u>	8	

D3566-1	Manufactured	No	230	Each	31.0000	2	2	
D3566-1								
Gasket								
						**		<u>12/07/05</u>

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	-22	
81619	10	
FP002	53	
68924	2	
80919	3	
<u>83898</u>	16	

D3566-5	Manufactured	No	230	Each	21.0000	1	1	
D3566-5								
Gasket								
						**		<u>12/07/05</u>

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	12	
<u>82275</u>	12	
FP002	9	
80374	3	
82274	6	

W/O:		WORK ORDER CHANGES					
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QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER



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WORK ORDER
NO. 84893 MJS
120529

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

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07.09.04

B	UPDATE DRAWING FORMAT: RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>q</i>		
DRAWN	<i>CB</i>		
CHECKED	<i>PH</i>		
MFG. APPR.	<i>PH</i>		
APPROVED	<i>PH</i>		
DE APPR.	<i>PH</i>		
DATE	07.08.21		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2906	REV. B SHEET 1 OF 3
TITLE AH-1 (209) SKIDTUBE ASSEMBLY	SCALE NTS

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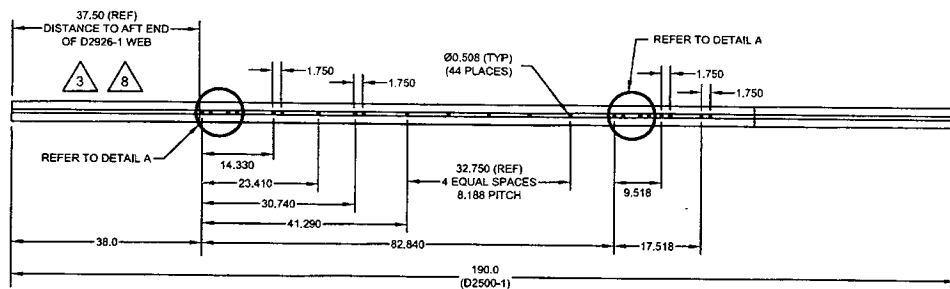
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

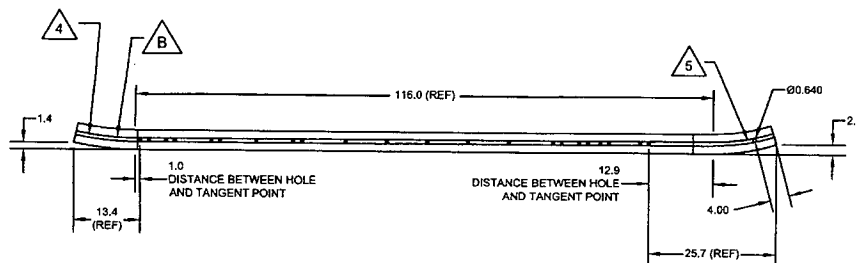
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

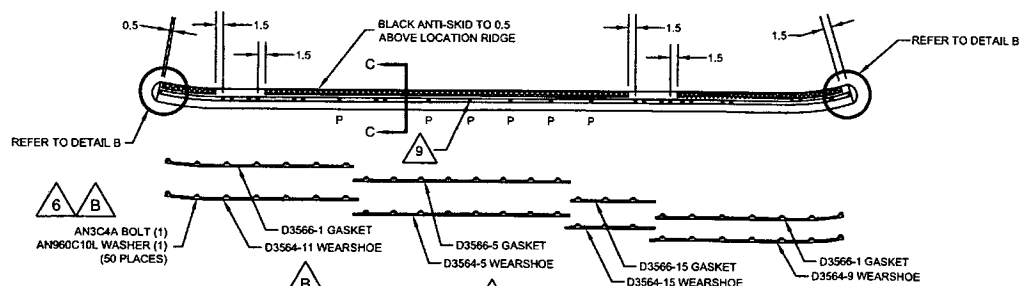
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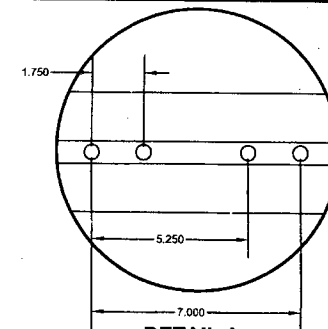
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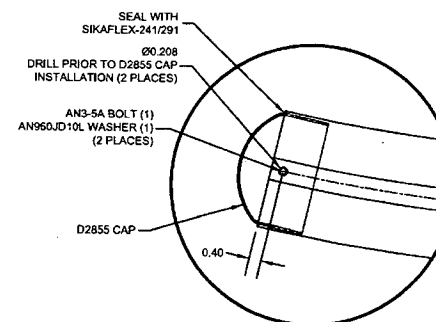
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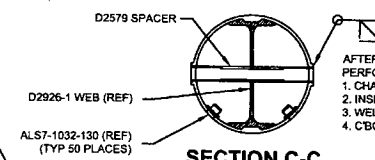
D2906-041 ASSEMBLY DETAIL



**DETAIL A
SCALE 1:4**



**DETAIL B
SCALE 1:4**



**SECTION C-C
SCALE 1:4**

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

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DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 2 OF 3
APPROVED	21	TITLE	SCALE
DE APPR.	21	AH-1 (209) SKIDTUBE ASSEMBLY	1:24
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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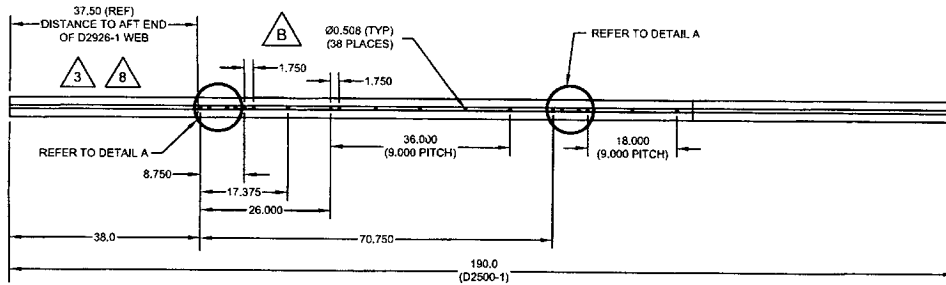
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

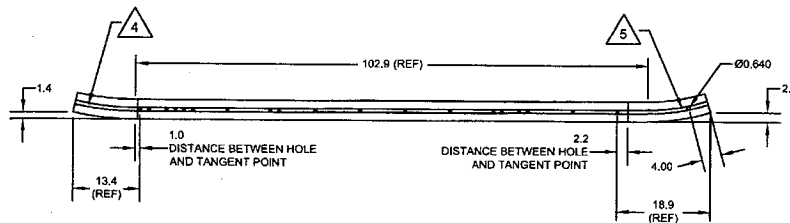
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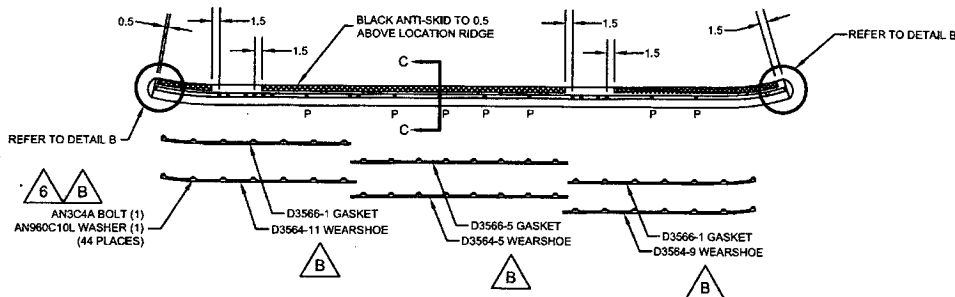
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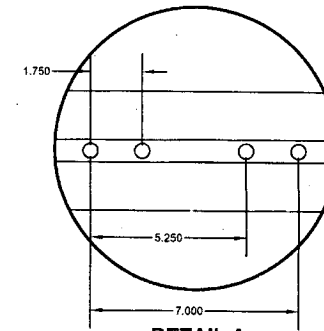
D2906-3 DRILLING DETAIL



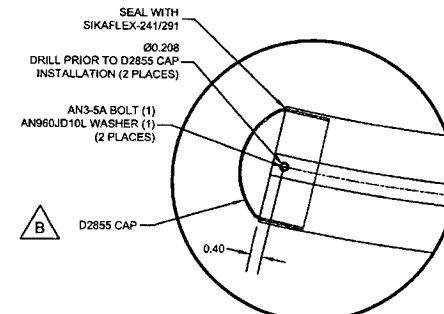
D2906-043 BENDING AND CUTTING DETAIL



D2906-043 ASSEMBLY DETAIL



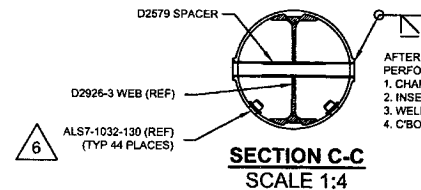
**DETAIL A
SCALE 1:4**



**DETAIL B
SCALE 1:4**

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**SECTION C-C
SCALE 1:4**

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MFG. APPR.	SH	D2906	SHEET 3 OF 3
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NOTE: Date & initial all entries